

Date: Wednesday, 6/6/2007 3:45:36 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	END PLATE
Job Number	32836		
Estimate Number	10547		
P.O. Number	N/A	Part Number	D30671
This Issue	6/6/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3067 REV A
First Issue	N/A	Project Number	N/A
Previous Run	31653	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>JL</u> 07.06.07	Due Date	6/30/2007
Comment	Est:03.01.21 Remove step 6 (Deburr) KJ Est Rev:B Now on Water jet 06-06-16 JLM	Qty:	160
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 10.5000 sf(s) 5052-H32 .063 Sheet Material: 5052-H32 (QQ-A-250/8) M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)
		Batch: <u>1103755</u> SAD 07/06/15 168
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3067 Dwg Rev: <u>A</u> Prog Rev: <u>A</u>
		2-Deburr if necessary <u>SAD 07/06/15 / 168</u> counted SAD 07/06/15 168
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/06/15 168
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <u>in 07.6.18</u>
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Bend as per Dwg D3067 <u>SAD 07/07/18</u> 168

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 32836

Part Number: D30671

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Counted

En 07/07/12

X168

Comment: INSPECT WORK TO NEXT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 4

JL. 07-07-12

168

8.0 QC21

FINAL INSPECTION/W/O RELEASE



JK8

Comment: FINAL INSPECTION/W/O RELEASE

En 07/07/13

Job Completion



Not 07-13

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32836
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	EM	Prototype Approval:	N/A
Date:	07/06/15	Date:	07/06/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	JF

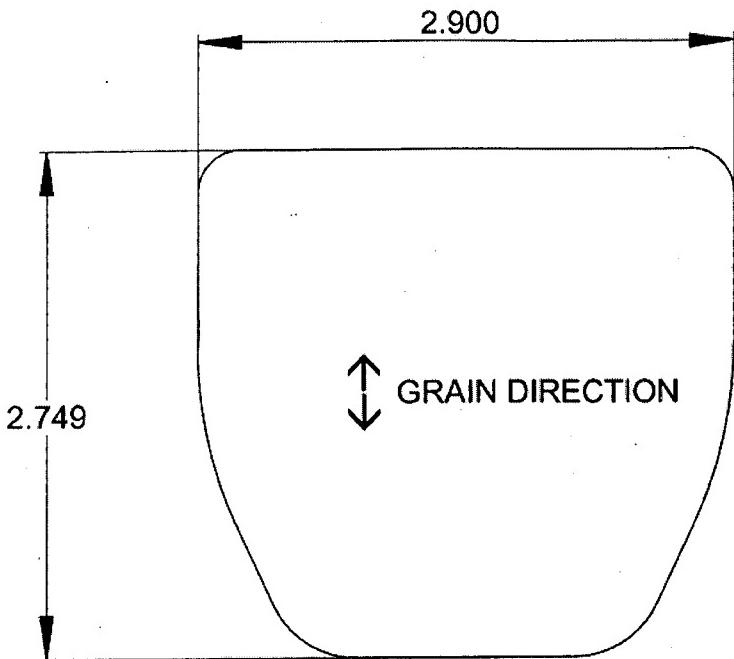


COPY ISSUED

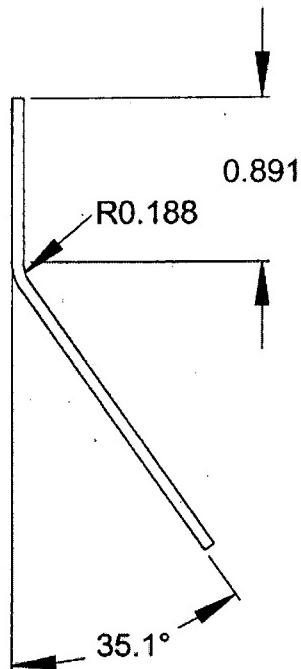
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3067
DATE	02.09.11	TITLE END PLATE
		SCALE 1:1

RELEASED
02.09.2011

A 02.09.11 NEW ISSUE



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 32836